

# Work Order ID 52428

September 23, 2009 2:24:54 PM



Page 1

Item ID: PB67-43001-79

Accept



Setup Start



Revision ID: *ATC per ECN 09-678*

Stop



Item Name: Lower Blade Support Ass'y

Start Date: 09/25/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 11/05/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *09-09-23* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001

Rev B1

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg PB67-43001

*PE 09-10-01*

*4* *0*

110

0.00



QC9- Inspect visual per QS1004- Fusion Welds

QC

Memo

0.00

Quality Control

*PD 09.10.02*

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*7 8010/02*

*(74)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52428

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Page 2

Item ID: PB67-43001-79

Accept

Setup Start

Revision ID: B1

Stop

Item Name: Lower Blade Support Ass'y

Start Date: 09/25/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 11/05/2009 Req'd Qty: 4.00

Customer:




Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 <i>M 18144</i>	0.00							
Powder Coating	Memo 1- put screws in nut plates before to keep thread clean TIME: <i>9:00</i> START <i>300°</i> FINISH TIME: <i>10:00</i> OVEN TEMPERATURE:	0.00		<i>BR 09-10-7</i>		<i>(4)</i>			
140  QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00		<i>⇒ 09/10/09</i>		<i>(4)</i>			
150  Packaging	Identify as per dwg & Stock Location: <i>ST437A</i>	0.00							
Packaging	Memo	0.00		<i>SAD 09-10-7</i>		<i>(4)</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 52428**

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Item ID: PB67-43001-79

Accept



Setup Start



Revision ID: B1

Stop



Item Name: Lower Blade Support Ass'y

Start Date: 09/25/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 11/05/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/08 JF

W 09-1008

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

fe sent to EMPLOYEE VE 07/10

# Picklist Print

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Work Order ID: 52428



Parent Item: PB67-43001-79RevB1



Parent Item Name: Lower Blade Support Ass'y

Start Date: 09/25/2009

Required Date: 11/05/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-171RevB1		Manufactured	No			100	Each	87.0000	24.0000			
Mounting Plate												

4 09.10.02

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST

87

41210

28

41563

59

PB67-43001-177RevB1

Manufactured No



Short Support Plate

100 Each 6.0000 4.0000



4 20

4 09.10.02

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST

6

41564

6

PB67-43001-179RevB1

Manufactured No



Short Sside Plate

100 Each 4.0000 8.0000



4

4 09.10.02

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST

4

41867

4

352431

4 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

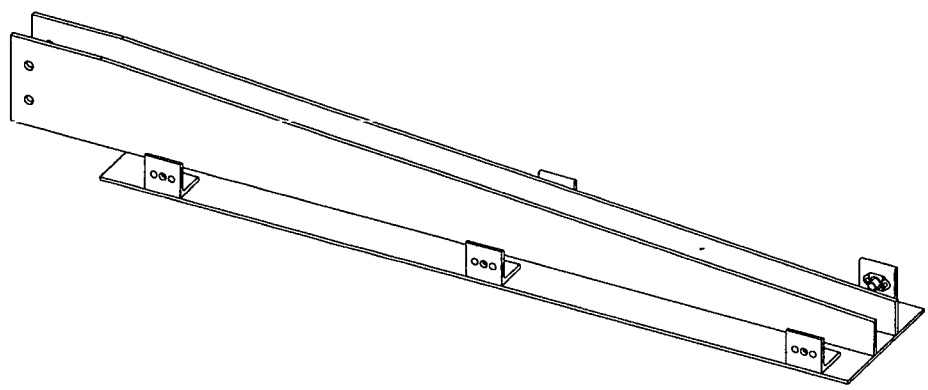
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



#52428



**B67-43001-79 LOWER BLADE SUPPORT ASSY**

ITEM	QTY -79	P/N	DESCRIPTION
1	X	B67-43001-79	LOWER BLADE SUPPORT ASSY
3	6	B67-43001-171	MOUNTING PLATE
4	1	B67-43001-177	SHORT SUPPORT PLATE
5	2	B67-43001-179	SHORT SIDE PLATE
7	12	MS20426AD3-4	RIVET
8	6	MS21075L3	NUT PLATE

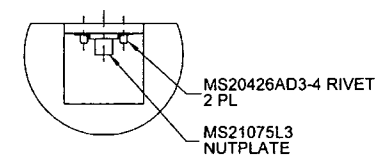
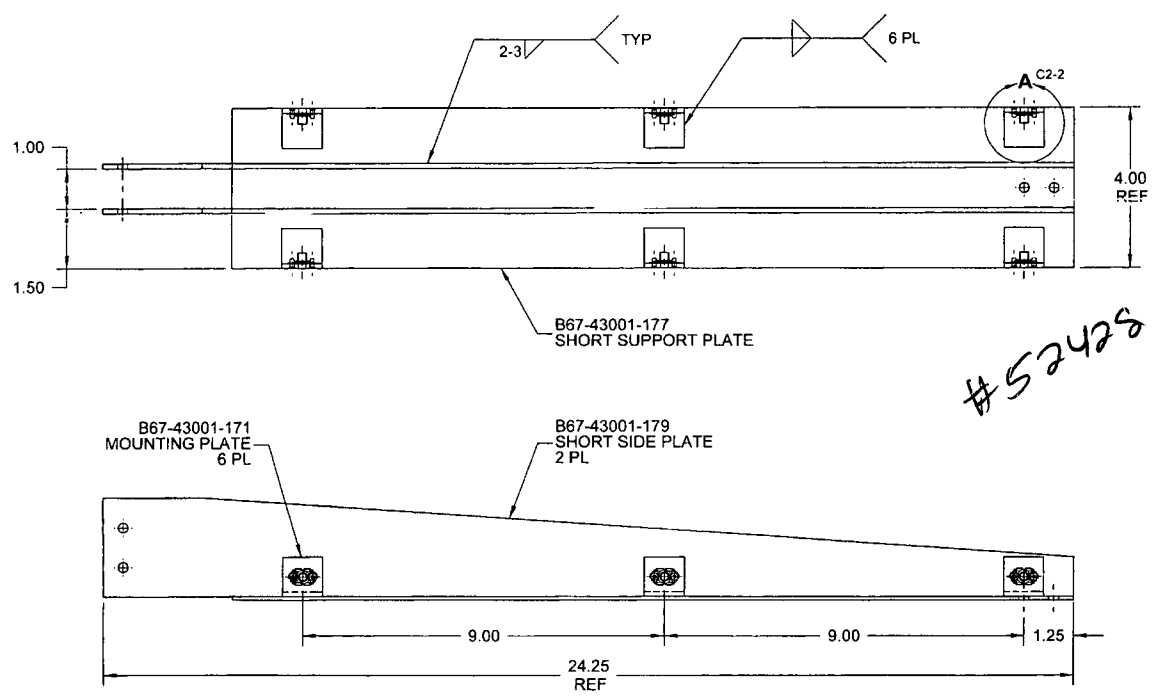
RELEASED  
2009-09-24  
NAP

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-79" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 1.96 lbs
  - 8) WELDING: PER DART QSI 004

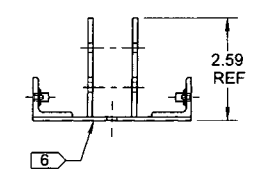
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 11 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.26
REV.	DESCRIPTION	BY	DATE
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS	DRAWING NO.	REV. C
CHECKED	AS	B67-43001-79	SHEET 1 OF 2
MFG. APPR.	AS	TITLE	SCALE
APPROVED	AS	LOWER BLADE SUPPORT ASSY	NTS
DE APPR.	N/A	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.06.26		

8 7 6 5 4 3 2

D  
C  
B  
A



**DETAIL A C2-2**  
SCALE 2X, 6 PL



#52428

**B67-43001-79 LOWER BLADE SUPPORT ASSY**

**RELEASED**  
2009-09-24  
MP

DESIGN	RW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	MS	DRAWING NO.	REV. C
MFG. APPR.	MS	<b>B67-43001-79</b>	SHEET 2 OF 2
APPROVED	MS	TITLE	SCALE
DE APPR.	N/A	<b>LOWER BLADE SUPPORT ASSY</b>	NTS
DATE	09.06.26	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1